

Date: Wednesday, 18/02/2009 11:09:17 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TUBE
<b>Job Number</b> : 45868	
<b>Estimate Number</b> : 13490	
<b>P.O. Number</b> :	<b>Part Number</b> : D37701
<b>This Issue</b> : 18/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3770 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 42962	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 25/02/2009 <b>Qty:</b> 15 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.02.18</u>	
<b>Comment</b> : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC Est Rev:B Added Drilling Tooling 08-08-26 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W065

6061T6 RD TUBE 1.00 x .065w



**Comment:** Qty.: 1.1926 f(s)/Unit Total : 17.8889 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch:

M 110778 (7X)

M 109116 (2X)

M 110752 (6X)

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



(15X)

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3770

2-drill holes thru to finish size as per dwg D3770 Using DT9410, Locate tube on stop labelled #1 and then drill holes labelled #1

3- deburr

3.0

QC5

INSPECT WORK TO CURRENT STEP

**Comment:** INSPECT WORK TO CURRENT STEP

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: TUBE

Job Number: 45868

Part Number: D37701

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-19

15

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: JSI

9/2/19

50

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24/19

Job Completion



MF 09-02-23

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8 7 6 5 4 3 2 1

D

D

C

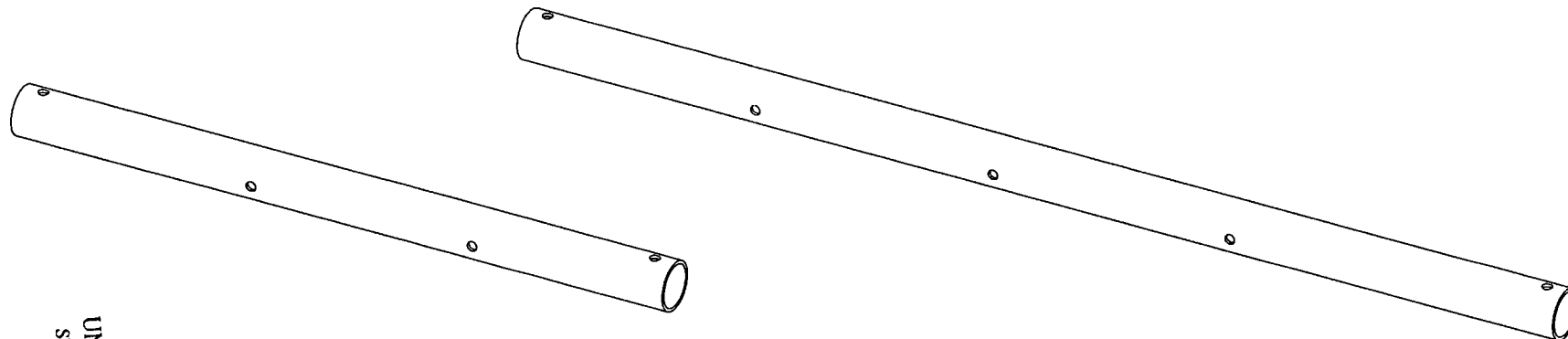
C

B

B

A

A



**D3770-1 TUBE**

**D3770-3 TUBE**

RELEASED  
08.07.10

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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 158103

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs  
D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	PA	D3770	SHEET 1 OF 3
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	TUBE	NTS
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
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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# Dart Aerospace Ltd

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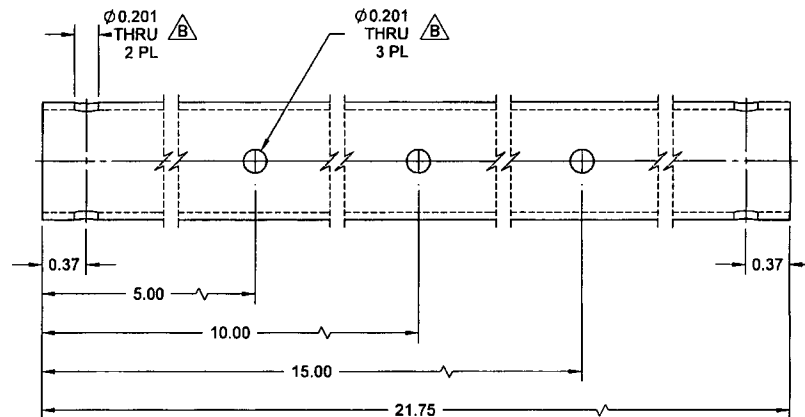
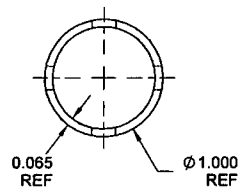
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**D3770-3 TUBE**

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11-05-07 10:14

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DRAWN	HS		
CHECKED	PL	DRAWING NO.	REV. B
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APPROVED	MS	TITLE	SCALE
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